












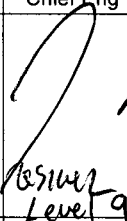

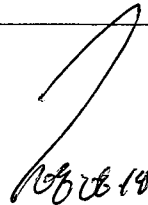

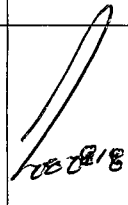
Date: Friday, 01/08/2008 3:32:37 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TUBE
Job Number :	40979		
Estimate Number :	13491		
P.O. Number :		Part Number :	D37703
This Issue :	01/08/2008 S.O. No. :	Drawing Number :	D3770 REVB
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	// Type : SMALL /MED FAB	Drawing Revision :	B
Previous Run :	40714	Material :	
Written By :		Due Date :	21/08/2008 Qty: 30 Um: Each
Checked & Approved By :	JLD 08.8.05		
Comment :	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
			
Comment: Qty.: 1.9031 f(s)/Unit Total : 57.0938 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <i>M108878</i> <i>SAD 08/08/14</i> <i>30</i>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to length as per dwg D3770 <i>SAD 08/08/14</i> <i>(30)</i> 2-drill holes thru to finish size as per dwg D3770 <i>mwf 08/08/17</i> 3- deburr <i>217/SAD 08/08/17</i> <i>(30)</i> <i>P70</i>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <i>0808.18</i> <i>(30)</i>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>08-08-18</i> <i>(130)</i>			
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>08-08-19</i> <i>(X30)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3770-3 PAR #: NO Fault Category: FAB - confirmed NCR: Yes No DQA: AS Date: 08.08.21
D3784-043/044
CD412-761-043/044 QA: N/C Closed: D Date: 08/28/26

NCR: <u>40979</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.18	2.0	Drilled Hole at WRONG ORIENTATION. operator ERROR RC: Lack of attention	 Level 9	Patch: hole ALROD Batch: <u>M106330</u> Q51004	 08/28/18	 08/28/18	 08/28/18 Q51012 Level 9	 08/28/18

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40979

Part Number: D37703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



30x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 512

8/8/19

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2019

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

B

D3770-1 TUBE**D3770-3 TUBE**

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RELEASED
08-07-10

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	Per	DRAWING NO.	REV. B
MFG. APPR.	HS	D3770	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	TUBE	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

8

7

6

5

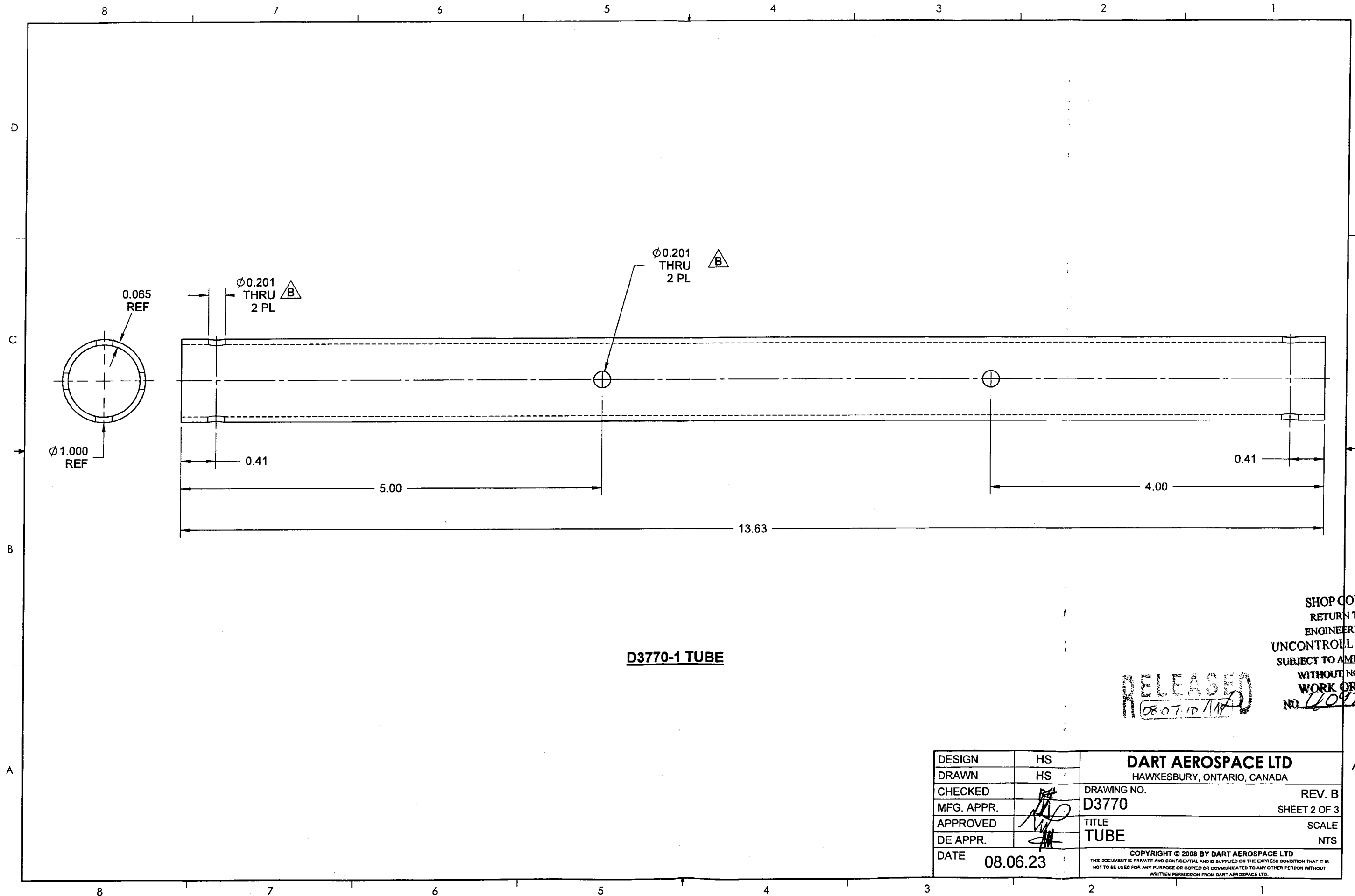
4

3

2

1

A

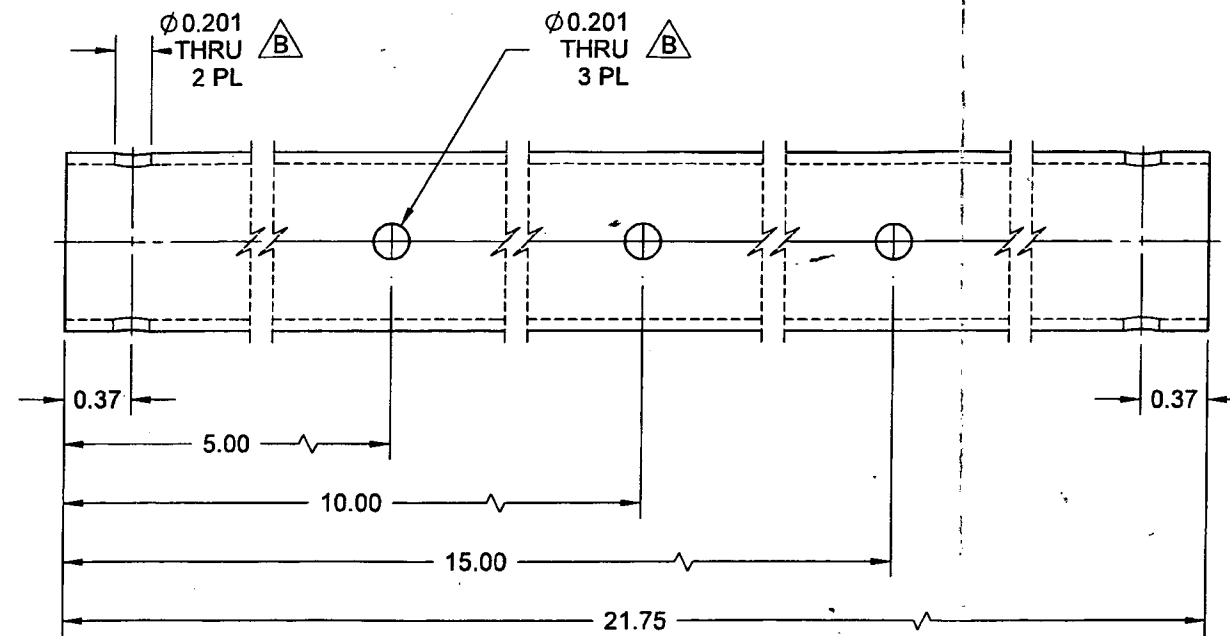
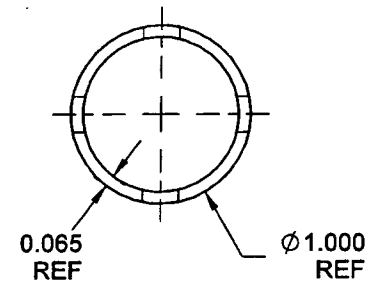


D3770-1 TUBE

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D3770-3 TUBE

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